



Dart Aerospace Ltd.
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RBE350A94-3700-C
Job Sheet 180177



Part No: RBE350A94-3700-C

Job Qty: 6 ea

Part Name: Swashplate Immobilizing Tools Adjustable Brace



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/29/18

Job Tracking No:

Due Date: 8/13/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE350A94-3700-C Rev 6 IPP Rev A 17.12.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	8/13/18	8/13/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	5 pcs	8/13/18	8/13/18	0.00	1.25	Small Fab-3		
120	QC	5 pcs	8/13/18	8/13/18	0.00	0.00	QC5		
130	Packaging	5 pcs	8/13/18	8/13/18	0.00	0.00	Packaging3-1		
140	QC21-SA	5 Ea	8/13/18	8/13/18	0.00	0.00	QC21		
Part Op 110 - -Bag and tag 3 RBE350A94-3700-C-1A per kit as per DWG sheet 1									
Descriptions:									

OCT 26 2018
GA141B
9-SS

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE350A94-3700-C-1A	Adjustable Brace Assembly	15 Ea (3 ea)	90-Start up Operation	5121401

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBE350A94-3700-C-1A	15	0	0

Part Specifications

Specifications could not be found.

Plex 7/23/18 7:58 AM dart.logan.david



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Container No: S121970



Part: RBE350A94-3700-C

Job No: 180177

Serial No/Batch: S121970

Revision: 6

Inspector:

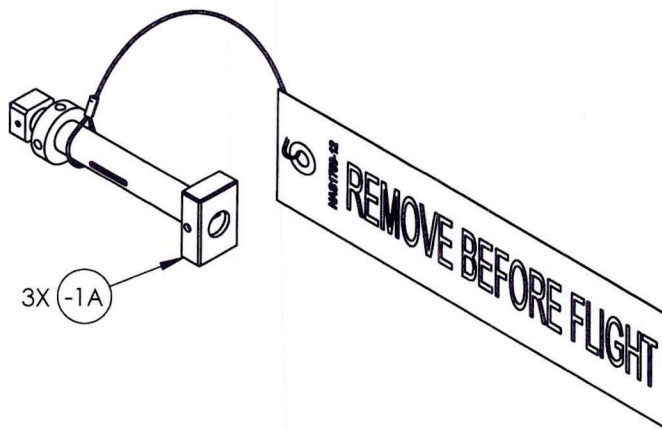
Exp Date:

Instructions:

Date: 10/26/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		BROKE OUT FROM KIT AS INDIVIDUAL TOOL.	7/10/2015		
4A		CH'D T/N WAS RBEA94-3700-C IS RBE350A94-3700-C, DELETED ASSY. FROM TOOL NAME.	10/23/2013	CFS	RW
5	15-0213	-01 CH'D HOLE WAS Ø5.1 mm IS Ø.192 - .187. -03 CH'D HOLE WAS Ø3.1 mm IS Ø.129 - .125, CH'D DIM WAS Ø.315 S.F. -07 IS Ø.3159 - .3150. -05 CH'D HOLE WAS Ø5.1 mm IS Ø.192 - .187. -07 CH'D HOLE WAS Ø3 mm IS .129 - .125, CH'D DIM WAS Ø.315 S.F. -03 IS Ø.3170 - .3164 ∇ .36.	8/14/2015	RJC	JAG
6	16-0286	-1A ADDED DRAWING. -01, -03, -09 -01 ADDED FINISH SPEC QMSI-6.2.2. B.O. REV D, -C DELETED. -01 CH'D DIM WAS Ø.620 S.F. -03 IS Ø.634 (S.F. -03), WAS .250 IS .250 +.000/-.005, WAS .130 THRU IS .132 +.010/-.000 (S.F. -11), WAS Ø.192/.187 THRU IS Ø.192/.187 THRU ALL (P.F. -13), DELETED DIM Ø.750 ∇ .47 MIN S.F. -05, ADDED DIM Ø.747/.742 (S.F. -05), .49, 2X FULL R. -03 CH'D DIM WAS Ø.3159/.3150 IS Ø.3159/.3155 (S.F. -07), WAS .217 IS .217 +.005/0.000, WAS 2X Ø.129/.125 THRU IS 2X Ø.129/.125 THRU ALL (P.F. -11). -05 CH'D DIM WAS Ø.625 THRU ALL $\square$ Ø.750 ∇ .473 S.F. -01 IS Ø.63 THRU ALL $\square$ Ø.755/.750 ∇ .473 (S.F. -01), WAS Ø.192/.187 THRU IS Ø.192/.187 THRU ALL (P.F. -13), WAS .217 IS .217 +.000/-.010. -07 CH'D DIM WAS Ø.3170/.3164 ∇ .36 IS Ø.3170/.3164 ∇ .37 (S.F. -03), WAS Ø.129/.125 THRU IS Ø.129/.125 THRU ALL (P.F. -11), WAS .217 IS .217 +.000/-.005, WAS .551 IS .55. -09 CH'D DIM WAS .20 IS 2X .20. ADDED -15, -17, -19.	2/28/2017	RJC	SM



NOTE:

CROSS REFERENCE NUMBERS:
 RED BARN No.'s = HELIPRODUCTS NO.'s
 RBE350A94-3700-C-01 = E-350A94-3700-25
 RBE350A94-3700-C-03 = E-350A94-3700-26
 RBE350A94-3700-C-05 = E-350A94-3700-27
 RBE350A94-3700-C-07 = E-350A94-3700-28
 FOR REFERENCE ONLY.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1A	3				2
	1		-01		TUBE	STEEL		3
	1		-03		ALL THREAD	B7 STEEL		4
	1		-05		BOTTOM	6061		5
	1		-07		TOP	6061		6
	1		-09		KNURLED NUT	STRESS PROOF		7
	2	B/O	-11		SLOTTED SPRING PIN	S.S.	Ø1/8 X 3/4 (MCMaster-CARR #92373A181)	2
	1	B/O	-13		SLOTTED SPRING PIN	S.S.	Ø3/16 X 1 (MCMaster-CARR #92373A251)	2
	1	B/O	-15		REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
	2	B/O	-17		FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMaster-CARR #3896T31)	2
	1	B/O	-19		LANYARD CABLE	COATED STEEL	Ø1/16 X 8 (CARR LANE #CL-2-C)	2
	ASSY -1A							

DART AEROSPACE		TITLE SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE	
DWG NO. RBE350A94-3700-C		REV 6	
MAT'L		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX $\pm$.005 FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$ 5° .X $\pm$.1 SURFACES = 125 $\sqrt$	
FINISH		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
SPEC		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: CLOUGH		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
CHECKED: DUERFELDT		USED ON MODEL	
OPPS APPR: ANDERSON		EUROCOPTER AS350/355	
QA APPR: LINDSAY		SCALE 1:8	
APPROVED: MACKOVJAK		DATE 8/21/2016	
		SHEET 1 OF 7	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									